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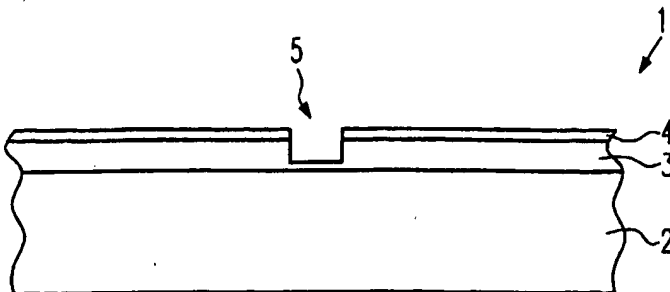
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(54) Title: **PANEL, A METHOD OF FABRICATING A PANEL AND A MACHINE FOR FABRICATING PANELS**



(57) Abstract: The invention relates to a panel (1), preferably floor panel comprising a decorative layer (4) with a decorative pattern a support layer (3) for supporting the decorative layer and a carrier (2) for supporting the support layer (3) and the decorative layer (4) wherein the support layer (3) is arranged at least partially between the decorative layer (4) and the carrier (2) wherein the decorative layer (4) is at least partially absent, preferably removed, such that the support layer (3) is visible. The invention furthermore relates to a method

of fabricating a panel, preferably a floor panel (1) comprising the step of preparing a sandwich of a decorative layer (4) with a decorative pattern a support layer (3) for supporting the decorative layer and a carrier (2) for supporting the support layer (3) and the decorative layer (4) wherein the support layer (3) is arranged between the decorative layer (4) and the carrier (2) with the step of removing partially the decorative layer (4) such that the support layer (3) becomes visible. Furthermore the invention relates to a machine for fabricating panels, preferably, floor panels comprising a) a support surface for supporting panels b) a circular saw which extends beyond the support surface by an amount of not more than 1.0 mm, preferably 0.5 mm, and c) a counter pressure mechanism for providing a counter pressure opposite of the circular saw.

## **PANEL, A METHOD OF FABRICATING A PANEL AND A MACHINE FOR FABRICATING PANELS**

The invention relates to a panel, a method of fabricating such panels and a machine for fabricating panels. The panels are preferably floor panels.

Panels comprise a decorative layer which has a decorative pattern in order to give the panel the desired decorative effect. The decorative pattern may eg. resemble a wood structure, stone structure or the like.

Such a decorative layer is usually supported by a support layer. The decorative layer and the support layer may form a decorative laminate such as a high pressure laminate (HPL).

The main body of the panel usually consists of a carrier which gives the stability to the panel.

With such floor panels it is possible to build a continuous surface in order to imitate wood flooring such as parquet flooring.

Some floorings, however, other than parquet have no continuous surface as in the case of a floor composed of floor tiles, stone pieces or wood pieces where the groove between the wood pieces is filled in with a particular material, such as a sealing material. Those kind of floorings can not be satisfactorily imitated with the existing panels.

The object of the present invention is therefore to provide improved panels and a method and a machine for fabricating such panels.

This problem is solved by the panel of claim 1, the method for fabricating a panel of claim 14 and a machine for fabricating panels of claim 19. Preferred embodiments are disclosed in the dependent claims.

In the panel the decorative layer is partially not present such that the support layer is visible and hence particular optical effects can be achieved.

It is preferable that the decorative layer is not present because it is removed. It may also not be present because it was not provided in the respective area.

Here it is preferable that the support layer is coloured or dyed such that the number of possible optical effects can be increased.

With the removal of the decorative layer a three dimensional structure is obtained which even more realistically imitates the abovementioned surfaces.

In order to give the impression of a seam between tiles, or the like, it is preferable to have the decorative layer removed in an area which is in the shape of a strip.

Furthermore it might be advantageous to also partially remove the support layer where the decorative layer is removed in order to ensure complete removal of the decorative layer within the fabrication tolerances.

In the case of the panel comprising an abrasive overlay in order to protect the decorative layer it might be possible to also have the abrasive overlay removed where the decorative layer is removed. The abrasive overlay may, nevertheless, also be present where the decorative layer is removed in order to protect the support layer.

The support layer is preferably a layer comprising kraft paper since it allows for good reproducibility and handling of the material.

In order to fabricate such panels, firstly a sandwich of a decorative layer, a support layer and a carrier is provided and afterwards the decorative layer is partially removed such that the support layer becomes visible. As mentioned above, here the support layer may also be partially removed in

order to obtain complete removal of the decorative layer within the fabrication tolerances.

In a preferred embodiment of the method the sandwich is cut into separate panels before or after the decorative layer is removed. Thereby it is possible to obtain more than one panel from the sandwich which means that the sandwich can be prepared at the scales of a few meters x a few meters while the panels may have smaller sizes such as, eg. 10-30 cms x 50-120 cms. The panels may also be square.

In a preferred embodiment the decorative layer is removed by a saw and, in particular, by a circular saw. Such a saw allows for a well-controlled and sharp cut which leads to a favourable optical impression.

In a preferred embodiment of the method the decorative layer is removed in the form of strips where the strips are perpendicular to each other. In this case, it is possible to obtain the optical impression of stone tiles or stone plates that are provided at a certain distance such that a seam is present which is filled with a filler.

The machine for fabricating such panels comprises a support surface which is suitable to support the panel while they are moved in order to remove the decorative layer. The machine further comprises a circular saw which extends beyond the support surface by an amount of not more than 1 mm and preferably not more than 0.5 mm. This means that the cutting depth of the circular saw into the panels is in the range of 0.1 to 1.0 or only to 0.5 mm.

In order to obtain a cut with little fabrication tolerances a counter pressure mechanism is provided in order to press the panel against the support surface close to the circular saw. The counter pressure mechanism therefore is most preferably provided opposite to the circular saw.

Further embodiments of the panel, the fabrication method and the machine are shown in the enclosed Figures. Accordingly it is shown in:

- Fig. 1        a schematic cross-section of a panel,
- Fig. 2        a schematic cross-section of another panel,
- Fig. 3        a schematic cross-section of two joined panels,
- Fig. 4        a more detailed cross-section of a panel,
- Fig. 5        a three dimensional schematic view of a panel,
- Fig. 6        a three dimensional schematic view of a machine,
- Fig. 7        a schematic cross-section of a machine,
- Fig. 8        another schematic cross-section of a machine,
- Fig. 9        a schematic view of another machine.

Herein mainly the case of the decorative layer being removed will be discussed. However the same discussion applies for the case the decorative layer being absent because it was not provided.

In Fig. 1 a schematic cross-section of a panel 1 is shown. The panel 1 has a carrier which is made of HDF, MDF, cardboard, wood, plastic, metal or the like. On top of the carrier 2 the decorative laminate is provided. The decorative laminate comprises the decorative layer 4 and the support layer 3. The decorative laminate may eg. be a high pressure laminate (HPL).

As can be seen in Fig. 1 in the middle in an area 5 the decorative layer 4 is absent. This may be because the decorative layer was not provided in this

area 5 or because it was removed. In the area 5 part of the support layer 3 is removed. Since the decorative layer 4 is absent (not provided or removed) in the area 5, the support layer can be seen in the area 5.

While in Fig. 1 the decorative layer is removed in an area which is not located at the edge of the panel but rather somewhere in the middle, in Fig. 2 the case is shown where the decorative layer 4 is removed in an area 5, which is located at the edge of the panel 1.

As can be seen in Fig. 2, the decorative layer 4 is removed only on the right edge of the panel in the area 5 but is not removed on the opposite edge, namely the left edge in Fig. 2.

In Fig. 2 furthermore connecting portions 6 and 7 are provided which allow for an interconnection between the panels at the respective edges.

As can be seen in Figs. 1 and 2 the cross section of the area 5 where the decorative layer is removed is rectangular. The recess which is formed by the removal of the decorative layer 4 has a rectangular cross-section.

In Fig. 3 it is shown how two panels are joined at their respective edges. The connecting portions 6 and 7 are engaged. An additional clamp 12 may be provided in order to force the two panels towards each other.

Any other engagement mechanism, with or without an additional clamp 12, may be provided in order to join two panels.

As can be seen in Fig. 3, since the area 5 is only part of one of the two panels the seam between the two panels is located in a corner of the recess of the area 5. The seam is therefore almost or, indeed, invisible to the human eye, provided that the fabrication tolerances are sufficiently small.

If on both edges of the panel shown in Fig. 3 the decorative layer 4 is removed then the seam is in the middle of the recess and is more easily visible. This case, however, offers the advantage that the panels may be joined in any orientation.

In Fig. 4 a more detailed schematic cross-section of the panel is shown. Below the carrier 2 an under layer 9 is provided in order to provide for eg. protection of the carrier 2 against abrasion, humidity, or the like. Furthermore a sound absorbing layer 9, or the like, may be provided additionally or as an under layer of the carrier 2.

The support layer 3 is composed of two layers of kraft paper. As shown in Fig. 4, the recess 5 penetrates only into the first kraft paper layer. However, it may also completely penetrate the first kraft paper layer and may further also penetrate into the second kraft paper layer. The recess may also penetrate in some areas into the first kraft paper and in other areas into the second kraft paper (e.g. due to fabrication tolerances an/or in order to achieve special optical affect due to different colours of the two kraft papers.

Further, above the decorative layer 4 an abrasive overlay 8 is provided in order to protect the decorative layer 4 against abrasion.

The composite of the support layer 3, the decorative layer 4 and the abrasive overlay 8 forms the decorative laminate 10. Such a decorative laminate 10 is usually fabricated independently of the carrier and is then glued with glue 11 to the carrier 2.

The decorative layer 4 may be a printed paper which allows for the a great variety of possible optical effects at low cost.

Fig. 5 shows a three-dimensional view of a panel. On the top surface of the panel the decorative layer 4 is absent in the areas 5a and 5b. The area 5b

is located along the long edge of the panel. The areas 5a are located in parallel to the short edge. One of the areas 5a is located at the short edge. (see Fig. 5, right upper end of the panel).

By providing a plurality of areas 5a it is possible to obtain an effect of square or rectangular tiles, stone plates, wood panels or the like, which are smaller than the panel itself.

In Fig. 6, 7 and 8 a machine for fabricating panels is shown. The machine comprises a support surface 17 on which panels may be hold and/or moved. Below the support surface 17 the axis 14 of a circular saw with the circular saw blade 13 is provided. The top of the blade 13 extends as little as 1 mm or less as eg. 0.5 mm or even less beyond the upper surface of the support surface 17 (see reference sign d in Fig. 8). Above the support surface 17 a wheel, eg. a rubber wheel 18, is provided. The rubber wheel has a rubber tyre 19 and can be rotated around an axis 21. The wheel 18 allows to exert pressure on a panel which is between the wheel 18 and the supporting surface 17. Thereby it is assured that the panel lies flat on the supporting surface 17 such that the depth of the cut provided by the circular saw blade 13 is uniform along the panel.

While in Fig. 7 the wheel 18 is positioned slightly to the left from the saw blade 13 it may also be positioned directly above or on the right side of the saw blade 13.

The axis 21 may also be connected to a motor 22 which rotates the axis 21 (see reference sign 23). In this way, the wheel 18 is suitable to transport the panel 1 along the supporting surface 17.

As can be seen in Fig. 8, the axis 14 of the circular saw blade 13 may be provided at a lever 24. The lever 24 can be movable such that the blade 13 may be moved downwards. In this position the blade 13 will not cut the panel 1.



In order to finely tune the cut depth of the blade 13 the height of the supporting surface 17 may be provided adjustably. The height 17 may eg. be changed by means of screws, or the like (not shown).

Fig. 9 shows a preferred embodiment of the machine. In the machine two circular saws are provided in order to fabricate panels which have the decorative layer removed in strips which are orthogonal to each other.

The machine comprises an axis 14 which has four circular saw blades 13 provided thereon and which is powered by a motor 15. A panel 1 with the decorative layer 4 on top which has not yet been removed, is moved in direction 25. Then when passing the circular saw blades 13 the decorative layer 4 is removed on the lower side of the panel 1 in parallel to the short edge of the panel 1. Since four blades 13 are provided four areas 5a are produced where the decorative layer is removed. Instead of four blades also one, two, three, five or more blades may be provided

In a direction perpendicular to the axis 14 another circular saw with an axis 14', a blade 13' and a motor 15' is provided. The blade 13' is provided perpendicular to the blades 13. The axis 14' and the blade 13' however may also be provided at different angles than 90° with respect to the axis 14 and the blades 13 in the case that other optical effects are desired.

When the panel 1 is moved along the direction 26 the blade 13' provides for the area 5b along the long edge of the panel 1 when the decorative layer 4 is removed.

A preferred embodiment of the method for fabrication is described in the following.

First, a sandwich comprising a decorative layer, a support layer and a carrier is provided. Such a sandwich may have an extension of several

meters x several meters. This allows for the fabrication of more than one panel from a sandwich prepared as such.

In the next step the decorative layer is partially removed such that the support layer becomes visible. When removing the decorative layer the support layer may also be partially removed.

In the case that the sandwich is larger than a single panel, the sandwich may be cut into single panels before or after removing the decorative layer.

The decorative layer is preferably removed by a saw, and in particular by a circular saw, since it allows for a very accurate and reproducible removal of the decorative layer. Here it has to be kept in mind that the support layer is of a thickness of about 0.4 mm and therefore the depth of the cut has to be performed with high accuracy.

In another step before or after removal of the decorative layer, the side edges (long and short edges) can be provided with connecting portions.

The panels described herein are in particular for flooring. They may be, however, also be useful, adapted or intended for decorating walls, doors or ceilings or the like.

**CLAIMS**

1. Panel (1), preferably floor panel, comprising  
  
a decorative layer (4) with a decorative pattern,  
  
a support layer (3) for supporting the decorative layer and  
  
a carrier (2) for supporting the support layer (3) wherein the support layer (3) is arranged at least partially between the decorative layer (4) and the carrier (2)  
  
**characterized in that**  
  
the decorative layer (4) is at least partially absent, preferably removed, such that the support layer (3) is visible.
2. Panel of claim 1, **characterized by** the decorative layer (4) being absent at least in an area (5a,5b) located at an edge of the panel (1).
3. Panel of any of claims 1 or 2, **characterized by** the decorative layer (4) being absent in an area (5a,5b) located at one edge of the panel (1) but not at the opposite edge.
4. Panel of any of claims 1 to 3, **characterized by** the decorative layer (4) being at least absent in an area (5a,5b) of the panel (1) which is not located at the edge of the panel (1) .
5. Panel of any of claims 1 to 4, **characterized by** the decorative layer (4) being absent in an area (5a,5b) which is a strip.

6. Panel of any of claims 1 to 5, **characterized in** that in the support layer (3) is partially absent, preferably removed, where the decorative layer (4) is absent.
7. Panel of any of claims 1 to 6, **characterized by** the panel (1) comprising an abrasive overlay (8) over the decorative layer (4).
8. Panel of claim 7, **characterized in** that the abrasive overlay (8) is absent where the decorative layer (4) is absent.
9. Panel of any of claims 1 to 8, **characterized by** the decorative layer (4) being a printed paper.
10. Panel of any of claims 1 to 9, **characterized by** the support layer (3) being a layer comprising kraft paper, which is preferably coloured or dyed.
11. Panel of any of claims 1 to 10, **characterized by** the carrier (2) comprising HDF, MDF, plastic, wood or the like.
12. Panel of any of claims 1 to 11, **characterized by** the cross section of the area (5a,5b) where the decorative layer (4) is absent being rectangular.
13. Panel of any of claims 1 to 12, **characterized by** connecting portions (6,7) at the edges of the panel (1) for connecting the panels (1) by snapping, tilting, clicking or the like with or without play.
14. Method of fabricating a panel, preferably a floor panel (1), comprising the step of preparing a sandwich of  
  
a decorative layer (4) with a decorative pattern  
  
a support layer (3) for supporting the decorative layer and

a carrier (2) for supporting the support layer (3) wherein the support layer (3) is arranged between the decorative layer (4) and the carrier (2),

**characterized by**

the step of removing partially the decorative layer (4) such that the support layer (3) becomes visible or by not providing the decorative layer in some area.

15. Method of claim 14, **characterized in** that in the step of removing the decorative layer (4) the support layer is also partially removed.
16. Method of any of claims 14 or 15, **characterized in** that the sandwich is cut into single panels (1) before or after the step of removing the decorative layer (4).
17. Method of any of claims 15 to 16, **characterized in** that the decorative layer (4) is removed by a saw (13), preferably a circular saw.
18. Method of any of claims 14 to 17, **characterized in** that the decorative layer (4) is removed in an area (5a,5b) of the shape of a stripe or preferably a plurality of stripes, where some of those stripes are preferably in an perpendicular orientation to each other.
19. Machine for fabricating panels, preferably floor panels, comprising
  - a support surface (17) for supporting panels (1)
  - a saw, preferably a circular saw (13), which extends beyond the support surface by an amount of not more than 1.0 mm, preferably 0.5 mm, and

- a counter pressure mechanism for providing a counter pressure opposite of the circular saw.

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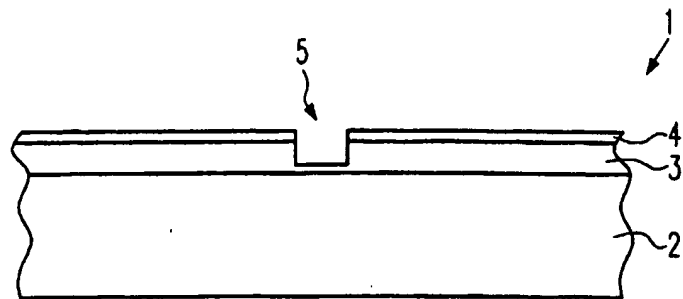


Fig.1

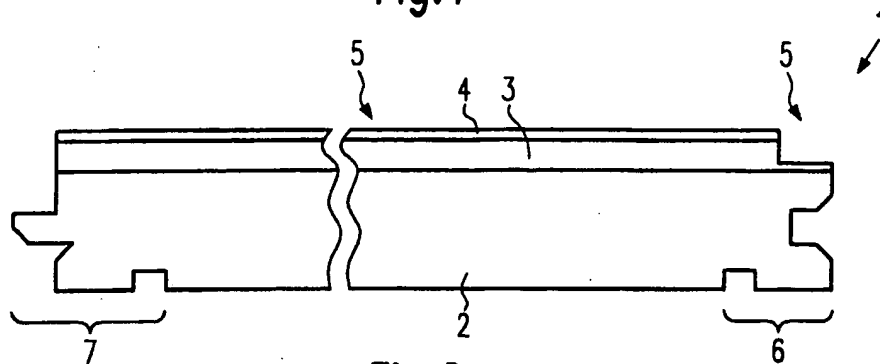


Fig.2

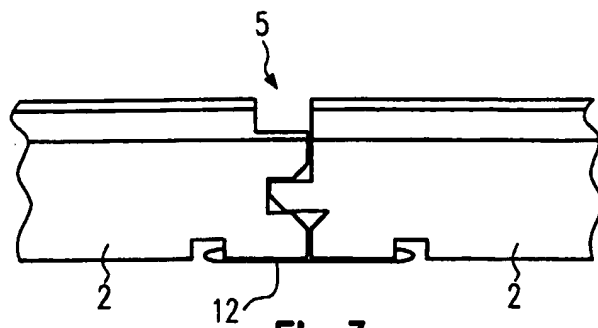


Fig.3

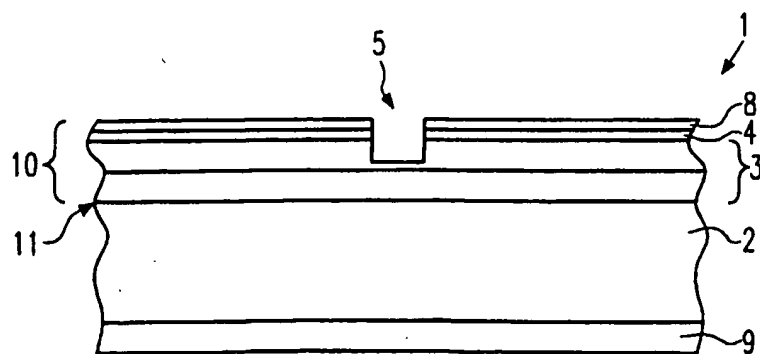


Fig.4

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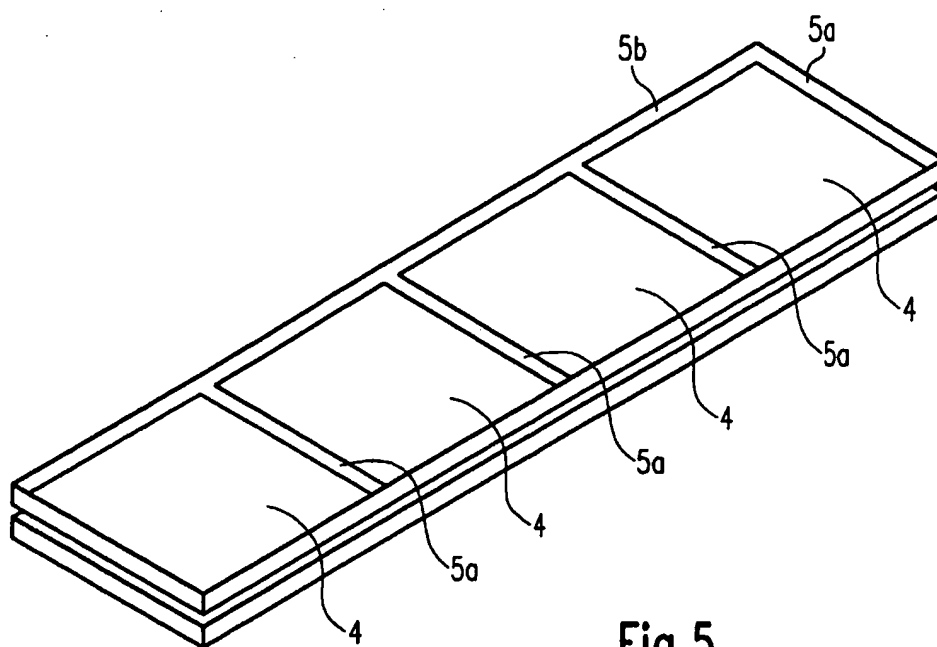


Fig.5

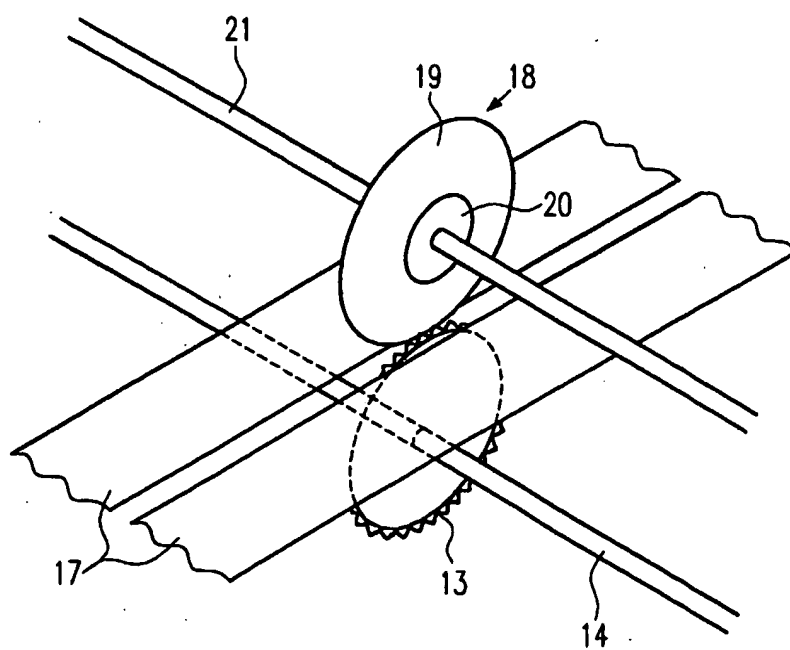


Fig.6



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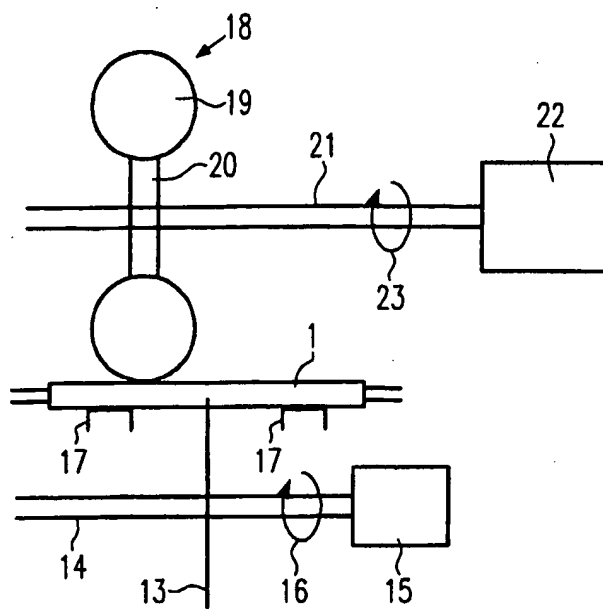


Fig.7

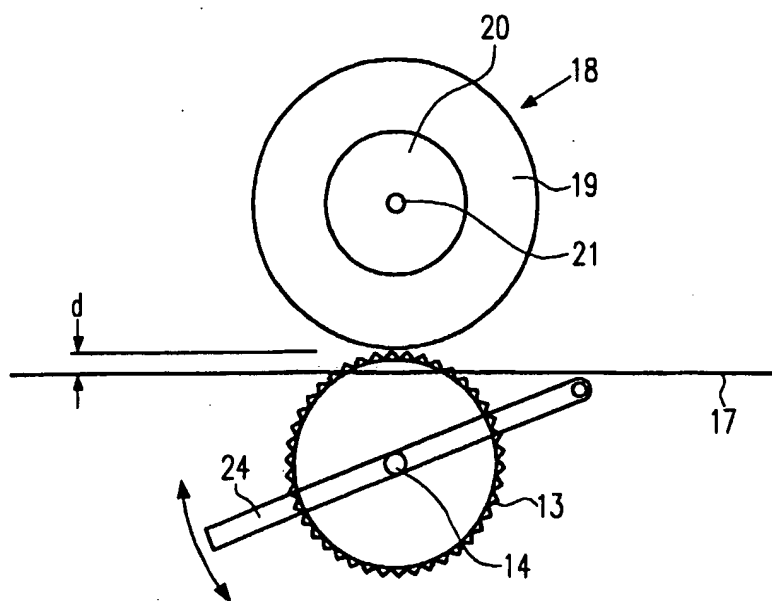
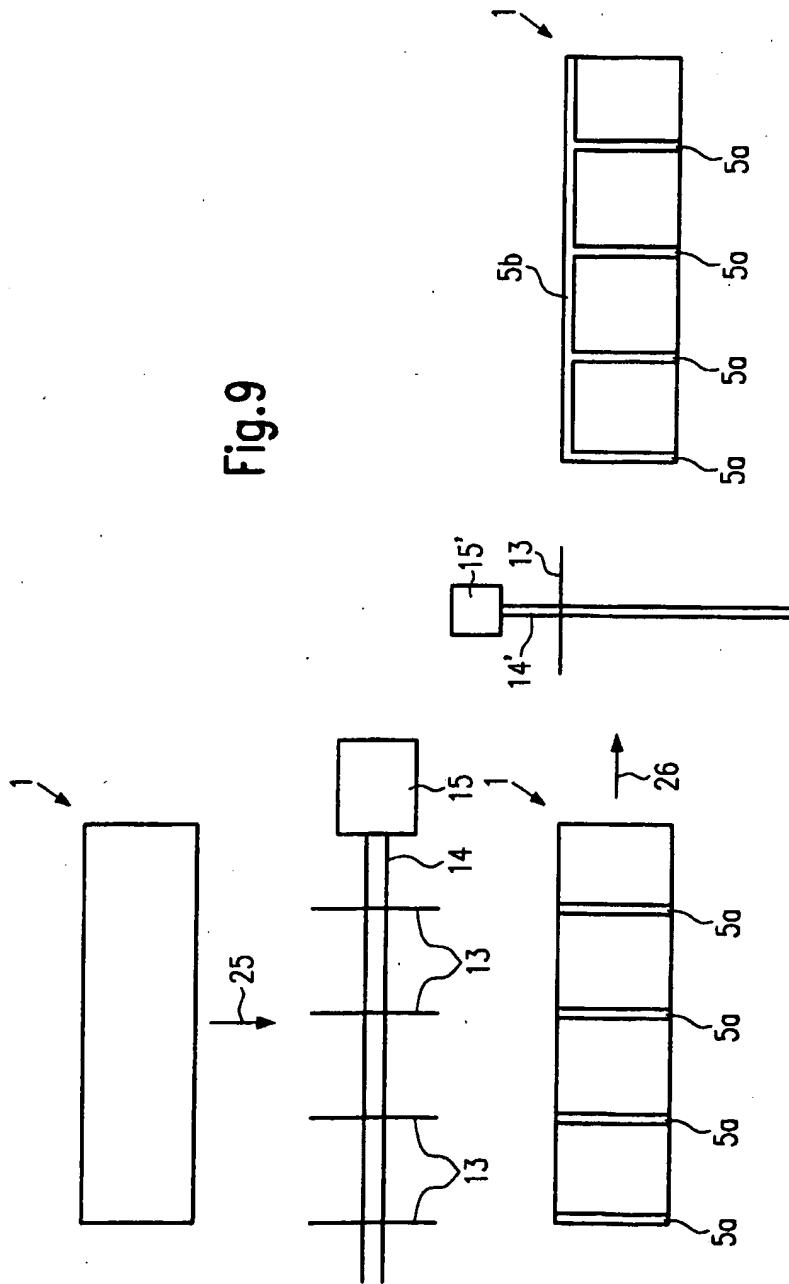


Fig.8

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Fig.9



# INTERNATIONAL SEARCH REPORT

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<b>A. CLASSIFICATION OF SUBJECT MATTER</b> IPC 7    B44C1/22    E04F15/022    B32B21/04    B32B31/16		
According to International Patent Classification (IPC) or to both national classification and IPC		
<b>B. FIELDS SEARCHED</b> Minimum documentation searched (classification system followed by classification symbols) IPC 7    B44C    E04F    B32B		
Documentation searched other than minimum documentation to the extent that such documents are included in the fields searched		
Electronic data base consulted during the international search (name of data base and, where practical, search terms used) EPO-Internal		
<b>C. DOCUMENTS CONSIDERED TO BE RELEVANT</b>		
Category *	Citation of document, with indication, where appropriate, of the relevant passages	Relevant to claim No.
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A	the whole document	4, 6-8, 12, 13
X	AT 387 621 B (DANA TUERENINDUSTRIE ; DANA TUERENINDUSTRIE (OO)) 27 February 1989 (1989-02-27) page 5, lines 4-45; figures 1-4	1, 5, 6, 11, 14, 15, 17, 19
A	the whole document	2-4, 7-10, 13, 16, 18
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<input checked="" type="checkbox"/> Further documents are listed in the continuation of box C. <span style="margin-left: 100px;"><input checked="" type="checkbox"/> Patent family members are listed in annex.</span>		
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Date of the actual completion of the international search  <div style="text-align: center; font-weight: bold;">4 April 2005</div>		Date of mailing of the international search report  <div style="text-align: center; font-weight: bold;">13/04/2005</div>
Name and mailing address of the ISA European Patent Office, P.B. 5818 Patentlaan 2 NL - 2280 HV Rijswijk Tel. (+31-70) 340-2040, Tx. 31 651 epo nl, Fax: (+31-70) 340-3016		Authorized officer  <div style="text-align: center; font-weight: bold;">Golombek, G</div>

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A	US 6 006 486 A (MORIAU STEFAN SIMON GUSTAAF ET AL) 28 December 1999 (1999-12-28) column 2, line 66 - column 4, line 42; figures 2-7 -----	13

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International Application No

PCT/EP2005/000230

Patent document cited in search report	Publication date	Patent family member(s)	Publication date
US 6006486	A	ID 17097 A	04-12-1997
		JP 11510869 T	21-09-1999
		MA 24198 A1	31-12-1997
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# PATENT COOPERATION TREATY

# PCT

## INTERNATIONAL PRELIMINARY REPORT ON PATENTABILITY

(Chapter I of the Patent Cooperation Treaty)

(PCT Rule 44bis)

Applicant's or agent's file reference PCT2217TSy]	<b>FOR FURTHER ACTION</b>	See item 4 below
International application No. PCT/EP2005/000230	International filing date ( <i>day/month/year</i> ) 12 January 2005 (12.01.2005)	Priority date ( <i>day/month/year</i> ) 16 January 2004 (16.01.2004)
International Patent Classification (8th edition unless older edition indicated) See relevant information in Form PCT/ISA/237		
Applicant BERRY FINANCE NV		

1. This international preliminary report on patentability (Chapter I) is issued by the International Bureau on behalf of the International Searching Authority under Rule 44 *bis*.1(a).
  2. This REPORT consists of a total of 7 sheets, including this cover sheet.
- In the attached sheets, any reference to the written opinion of the International Searching Authority should be read as a reference to the international preliminary report on patentability (Chapter I) instead.

3. This report contains indications relating to the following items:

- |                                     |              |   |
|-------------------------------------|--------------|---|
| <input checked="" type="checkbox"/> | Box No. I    | Basis of the report   |
| <input type="checkbox"/>            | Box No. II   | Priority  |
| <input type="checkbox"/>            | Box No. III  | Non-establishment of opinion with regard to novelty, inventive step and industrial applicability  |
| <input type="checkbox"/>            | Box No. IV   | Lack of unity of invention  |
| <input checked="" type="checkbox"/> | Box No. V    | Reasoned statement under Article 35(2) with regard to novelty, inventive step or industrial applicability; citations and explanations supporting such statement |
| <input type="checkbox"/>            | Box No. VI   | Certain documents cited   |
| <input checked="" type="checkbox"/> | Box No. VII  | Certain defects in the international application  |
| <input type="checkbox"/>            | Box No. VIII | Certain observations on the international application   |

4. The International Bureau will communicate this report to designated Offices in accordance with Rules 44bis.3(c) and 93bis.1 but not, except where the applicant makes an express request under Article 23(2), before the expiration of 30 months from the priority date (Rule 44bis .2).

The International Bureau of WIPO 34, chemin des Colombettes 1211 Geneva 20, Switzerland  Facsimile No. +41 22 338 82 70	<table border="1" style="width: 100%; border-collapse: collapse;"> <tr> <td style="padding: 2px;">Date of issuance of this report 17 July 2006 (17.07.2006)</td> </tr> </table> <table style="width: 100%;"> <tr> <td style="width: 50%; vertical-align: top;">                             Authorized officer                               Ellen Moyse                         </td> <td style="width: 50%; vertical-align: top;">                             e-mail: pt05@wipo.int                         </td> </tr> </table>	Date of issuance of this report 17 July 2006 (17.07.2006)	Authorized officer  Ellen Moyse	e-mail: pt05@wipo.int
Date of issuance of this report 17 July 2006 (17.07.2006)				
Authorized officer  Ellen Moyse	e-mail: pt05@wipo.int			

# PATENT COOPERATION TREATY

REC'D 11 APR 2005

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From the  
INTERNATIONAL SEARCHING AUTHORITY

PCT

To:

see form PCT/ISA/220

## WRITTEN OPINION OF THE INTERNATIONAL SEARCHING AUTHORITY (PCT Rule 43bis.1)

Date of mailing  
(day/month/year) see form PCT/ISA/210 (second sheet)

Applicant's or agent's file reference  
see form PCT/ISA/220

**FOR FURTHER ACTION**  
See paragraph 2 below

International application No.  
PCT/EP2005/000230

International filing date (day/month/year)  
12.01.2005

Priority date (day/month/year)  
16.01.2004

International Patent Classification (IPC) or both national classification and IPC  
B44C1/22, E04F15/022, B32B21/04, B32B31/16

Applicant  
BERRY FINANCE NV

### 1. This opinion contains indications relating to the following items:

- ☒ Box No. I Basis of the opinion
- ☐ Box No. II Priority
- ☐ Box No. III Non-establishment of opinion with regard to novelty, inventive step and industrial applicability
- ☐ Box No. IV Lack of unity of invention
- ☒ Box No. V Reasoned statement under Rule 43bis.1(a)(i) with regard to novelty, inventive step or industrial applicability; citations and explanations supporting such statement
- ☐ Box No. VI Certain documents cited
- ☒ Box No. VII Certain defects in the international application
- ☐ Box No. VIII Certain observations on the international application

### 2. FURTHER ACTION

If a demand for international preliminary examination is made, this opinion will usually be considered to be a written opinion of the International Preliminary Examining Authority ("IPEA"). However, this does not apply where the applicant chooses an Authority other than this one to be the IPEA and the chosen IPEA has notified the International Bureau under Rule 66.1bis(b) that written opinions of this International Searching Authority will not be so considered.

If this opinion is, as provided above, considered to be a written opinion of the IPEA, the applicant is invited to submit to the IPEA a written reply together, where appropriate, with amendments, before the expiration of three months from the date of mailing of Form PCT/ISA/220 or before the expiration of 22 months from the priority date, whichever expires later.

For further options, see Form PCT/ISA/220.

### 3. For further details, see notes to Form PCT/ISA/220.

Name and mailing address of the ISA:



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**WRITTEN OPINION OF THE  
INTERNATIONAL SEARCHING AUTHORITY**

International application No.  
PCT/EP2005/000230

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**Box No. I Basis of the opinion**

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1. With regard to the **language**, this opinion has been established on the basis of the international application in the language in which it was filed, unless otherwise indicated under this item.
  - ☐ This opinion has been established on the basis of a translation from the original language into the following language , which is the language of a translation furnished for the purposes of international search (under Rules 12.3 and 23.1(b)).
2. With regard to any **nucleotide and/or amino acid sequence** disclosed in the international application and necessary to the claimed invention, this opinion has been established on the basis of:
  - a. type of material:
    - ☐ a sequence listing
    - ☐ table(s) related to the sequence listing
  - b. format of material:
    - ☐ in written format
    - ☐ in computer readable form
  - c. time of filing/furnishing:
    - ☐ contained in the international application as filed.
    - ☐ filed together with the international application in computer readable form.
    - ☐ furnished subsequently to this Authority for the purposes of search.
3. ☐ In addition, in the case that more than one version or copy of a sequence listing and/or table relating thereto has been filed or furnished, the required statements that the information in the subsequent or additional copies is identical to that in the application as filed or does not go beyond the application as filed, as appropriate, were furnished.
4. Additional comments:

**WRITTEN OPINION OF THE  
INTERNATIONAL SEARCHING AUTHORITY**

International application No.  
PCT/EP2005/000230

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**Box No. V Reasoned statement under Rule 43bis.1(a)(i) with regard to novelty, inventive step or  
Industrial applicability; citations and explanations supporting such statement**

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**1. Statement**

Novelty (N)	Yes: Claims	3,9,10,13,16,17
	No: Claims	1,2,4-8,11,12,14,15,18
Inventive step (IS)	Yes: Claims	
	No: Claims	3,9,10,13,16,17
Industrial applicability (IA)	Yes: Claims	1-18
	No: Claims	

**2. Citations and explanations**

**see separate sheet**

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**Box No. VII Certain defects in the international application**

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The following defects in the form or contents of the international application have been noted:

**see separate sheet**

**To point V**

**Claim 1**

The document D1 = GB-A-2 243 805 discloses a panel having a decorative layer (12) with a decorative pattern, a support layer (adhesive layer) for supporting the decorative layer (see page 4, first paragraph) and a carrier layer (10) for supporting the support layer, the support layer being arranged between the decorative and the carrier layer, whereby the decorative layer is at least absent such that the support layer is visible (see reference sign 14).

Thus, the subject-matter of claim 1 is not new and the claim itself does not meet the requirements of Article 33(2) PCT.

**Claims 2 - 13**

These dependent disclose features

- a which are either known from D1, compare e.g. the absent area being a strip according to claim 5 presently on file to figure 5 of D1, or
- b which a person skilled in the art is able to manage without being inventive using his general knowledge e.g. the connecting portions according to claim 13 pre-sently on file.

**Claim 14**

D1 also discloses a method of fabricating a panel by preparing a sandwich having a decorative, a support and a carrier layer and removing partially the decorative layer (see page 4, first complete paragraph)

Thus, the subject-matter of claim 14 is not new and the claim itself does not meet the requirements of Article 33(2) PCT.

**Claims 15 - 18**

These dependent disclose features

- a which are either known from D1, compare e.g. the absent area being a plurality of

- parallel stripes according to claim 18 presently on file to figure 5 of D1, or
- b which a person skilled in the art is able to manage without being inventive using his general knowledge e.g. the use of a saw according to claim 13 presently on file.

**Claim 19**

The document D2 = AT-B-387 621 discloses a machine for fabrication of panels (doors are regarded to be panels) comprising.

- a a support surface for supporting the panels (being a technical necessity to achieve a constant thickness of the material to be removed),
- b a tool (16) which extends beyond the support surface by a definite amount;
- and
- c a counter pressure mechanism for providing a counter pressure opposite the tool (being a technical necessity to be able to machine a surface).

The subject-matter of claim 19 differs from the machine known from D1 in that

- a the tool is a circular saw;
- b the deepness of the removed area should be not more than 1 mm.

The circumstance (a) cannot provide any inventive step to the subject-matter of the claim, since a circular saw is a common tool for machining wood (see page 1 presently on file).

Feature (b) seems to be a matter of design which a person skilled in the art will choose according to circumstances and the sort of decorative pattern.

Thus, the subject-matter of claim 1 does not involve an inventive step and the claim itself does not meet the requirements of Article 33(3)PCT.

**To point VII**

- 1 Independent claims are not in the two-part form in accordance with Rule 6.3(b) PCT, which in the present case would be appropriate, with those features known in combination from the prior art ( D1 or D2) being placed in a preamble (Rule 6.3(b)(i) PCT) and with the remaining features being included in a characterising part (Rule 6.3(b)(ii) PCT).

**WRITTEN OPINION OF THE  
INTERNATIONAL SEARCHING  
AUTHORITY (SEPARATE SHEET)**

International application No.

**PCT/EP2005/000230**

- 2 Contrary to the requirements of Rule 5.1(a)(ii) PCT, the relevant background art disclosed in the documents D1 and D2 is not mentioned in the description, nor are these documents identified therein.